



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBW109-3101-58-1 Job Sheet 190255



Part No: RBW109-3101-58-1

Job Qty: 1 pcs

Part Name: Hammer, Steel, Blade Corrosion and Voids Detection



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/6/19

Job Tracking No: SIOP

Due Date: 3/15/19

Created By: Dara Macdonald

Type: Stock

Description:

Note: DWG RBW109-3101-58-1 Rev3 IPP Rev A 17.11.28 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	1 pcs	3/15/19		0.00	0.20	Small Fab - 1	EXT-LOAD 1	AP 2019/02/27
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
110	QC 5	1 pcs	3/15/19		0.00	0.00	QC 5 - 10		Mickel
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 38		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
130	Packaging 3-1 - Stock - B4B	1 pcs	3/15/19		0.00	0.00	Packaging 3 - 1 - B4B		MAR 07 2019 68 9-89
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		



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www.dartaerospace.com

Container No: S157314



Part: RBW109-3101-58-1

Job No: 190255

Serial No/Batch: S157314

Revision: 3

Inspector:

Exp Date:

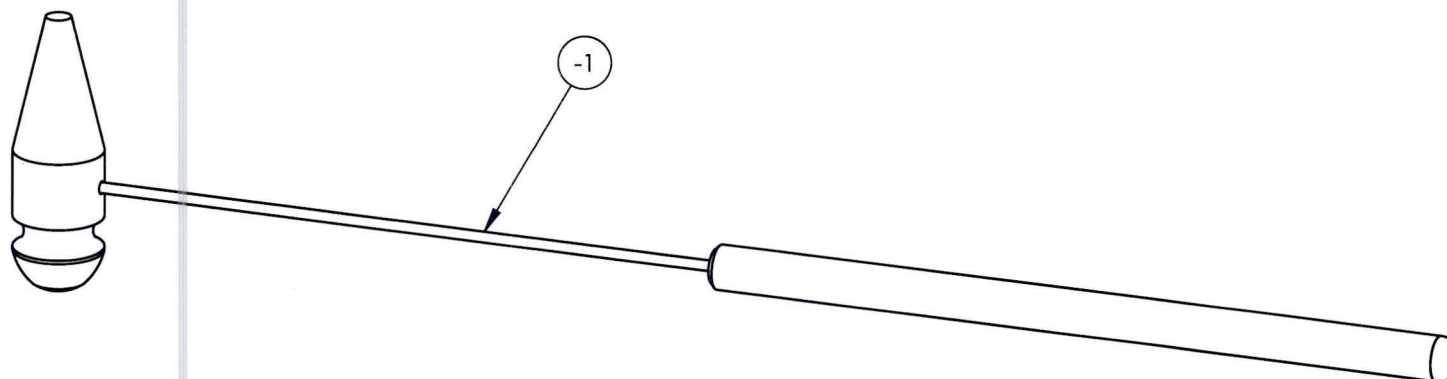
Instructions:

Date: 02/27/19

					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	MLL
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
140	QC 21 - FG	1 pcs	3/15/19	0.00 0.00	QC 21 - FG - 21	046
					QC 21 - FG - 70	21
					QC 21 - SA - 53	2.00
Part Op 100 - (Small Fab) Pack kit. Descriptions: 110 - (QC5- Inspect part completeness to step on W/O) 130 - (Identify as per dwg & Stock Location: _____) 140 - (QC21- Final Inspection - Work Order Release)						
Job BOM						
Part / Item	Component Name	Quantity	Operation	Container		
10137	Small Pistol Case, Plastic	1 Ea (1 ea)	100-Small Fab - 1	5151055		
RBW109-3101-58-1-1	Hammer, Steel	1 pcs (1 ea)	100-Small Fab - 1	5142834		
Job Allocations						
Operation	Component Part	Required	Inventory	Allocated		
100-Small Fab - 1	10137	1	24	0		
	RBW109-3101-58-1-1	1	9	0		
Part Specifications						
Specifications could not be found.						

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		RELEASED FOR PRODUCTION.	6/1/2015	DPD	JAG
2	16-0212	ADDED NOTE 2 SHEET 1, -1 CH'D DWG TO SHEET METAL TOLERANCE. -3 CH'D FINISH WAS CAD PLATE YELLOW IS ZINC PLATE ASTM B633 TYPE I SC 2, CH'D MATERIAL WAS 1018/1020 IS 1018/1020 CR. -5 CH'D DIM WAS $\pm .005$ IS $\pm .060/.058$. -7 CH'D DIM WAS $\pm .024$ IS $\pm .025$, CH'D ENGRAVE NOTE WAS LASER ENGRAVE T/N IS LASER ENGRAVE T/N, S/N, "MADE IN USA".	11/4/2016	RJC	JAG
3	17-0053	-7 CH'D ENGRAVE NOTE WAS LASER ENGRAVE T/N, S/N, "MADE IN USA" IS LASER ENGRAVE T/N.	2/20/2017	RJC	JAG



- NOTE:
 1. REF. AGUSTA T/N: 109-3101-58-1.
 2. -1 USED IN KITS: RBT18025, RBEA62309, RBT18510, & RBT18561.

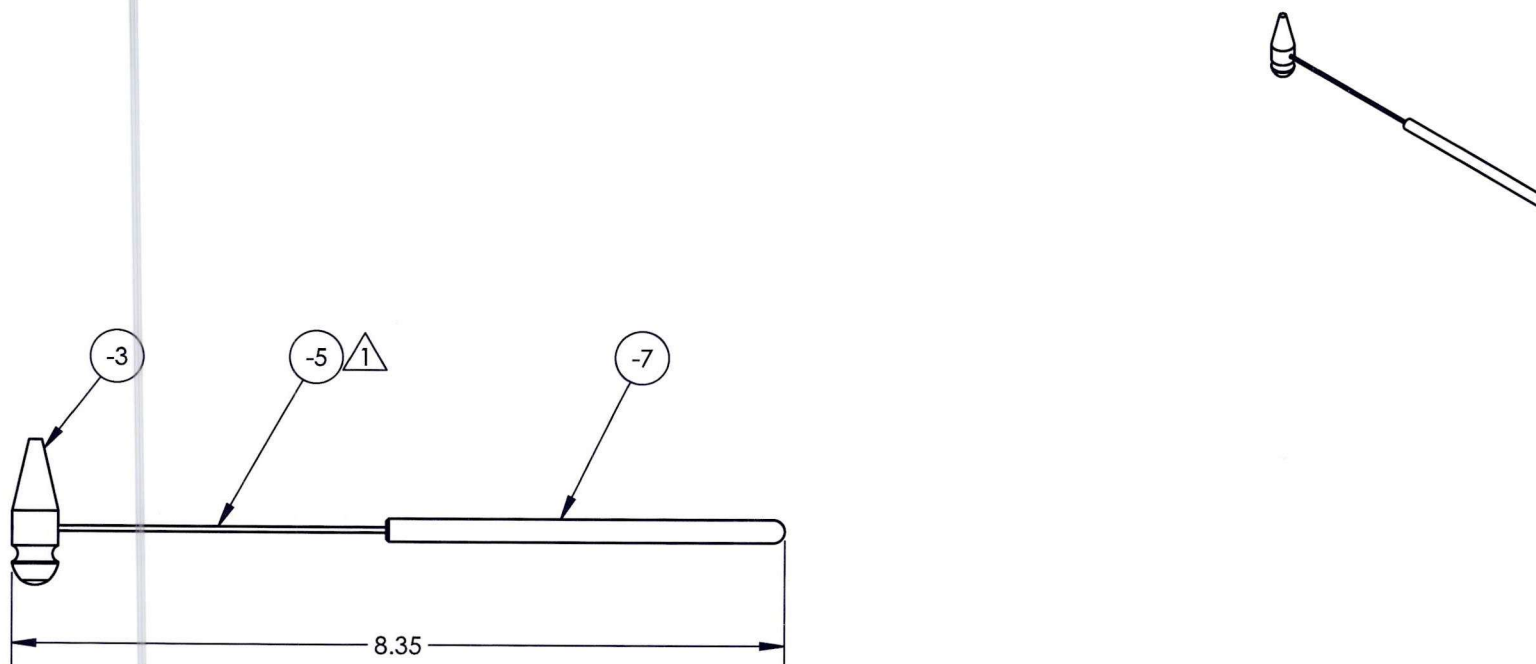
TEO ATTACHED

DART AEROSPACE											
TITLE HAMMER, STEEL, BLADE CORROSION AND VOIDS DETECTION											
DWG NO. RBW109-3101-58-1	REV 3										
<table border="1"> <tr> <td>MAT'L</td> <td>UNLESS OTHERWISE SPECIFIED</td> </tr> <tr> <td>HEAT</td> <td>DIMENSIONS ARE IN INCHES</td> </tr> <tr> <td>TREAT</td> <td>.XXX $\pm .005$ FRACTIONS $\pm 1/16$</td> </tr> <tr> <td>FINISH</td> <td>.XX $\pm .01$ ANGLES $\pm .5^\circ$</td> </tr> <tr> <td>SPEC</td> <td>.X $\pm .1$ SURFACES = 125</td> </tr> </table>		MAT'L	UNLESS OTHERWISE SPECIFIED	HEAT	DIMENSIONS ARE IN INCHES	TREAT	.XXX $\pm .005$ FRACTIONS $\pm 1/16$	FINISH	.XX $\pm .01$ ANGLES $\pm .5^\circ$	SPEC	.X $\pm .1$ SURFACES = 125
MAT'L	UNLESS OTHERWISE SPECIFIED										
HEAT	DIMENSIONS ARE IN INCHES										
TREAT	.XXX $\pm .005$ FRACTIONS $\pm 1/16$										
FINISH	.XX $\pm .01$ ANGLES $\pm .5^\circ$										
SPEC	.X $\pm .1$ SURFACES = 125										
<table border="1"> <tr> <td>DRAWN BY: DUERFELDT</td> <td>1. BREAK ALL SHARP EDGES .015 x 45° OR .015R</td> </tr> <tr> <td>CHECKED: DUERFELDT</td> <td>2. DIMENSIONAL LIMITS APPLY AFTER PLATING</td> </tr> <tr> <td>OPPS APPR: ANDERSON</td> <td>3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009</td> </tr> <tr> <td>QA APPR: LINDSAY</td> <td>USED ON MODEL</td> </tr> <tr> <td>APPROVED: GILBERT</td> <td>AW109/AW119</td> </tr> </table>		DRAWN BY: DUERFELDT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	CHECKED: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING	OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	QA APPR: LINDSAY	USED ON MODEL	APPROVED: GILBERT	AW109/AW119
DRAWN BY: DUERFELDT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R										
CHECKED: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING										
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009										
QA APPR: LINDSAY	USED ON MODEL										
APPROVED: GILBERT	AW109/AW119										
SCALE 1:1	DATE 3/12/2015 SHEET 1 OF 5										

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
	X		-1	1	HAMMER, STEEL			2
	1		-3		HAMMER HEAD	1018/1020 CR		3
	1		-5		SHAFT	S.S.	$\varnothing .059$ X 1 FT. (MCMASTER-CARR #8908K62) MODIFIED	4
	1		-7		HANDLE	6061		5
		B/O	-9	1	CASE	PLASTIC	SMALL PISTOL CASE (RSR GROUP #10137)	N/S
	ASSY -1							

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	16-0212	-1 CH'D DWG TO SHEET METAL TOLERANCE.	11/4/2016	RJC	JAG



NOTE:

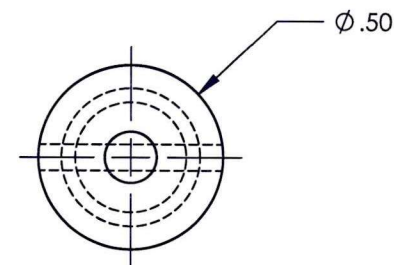
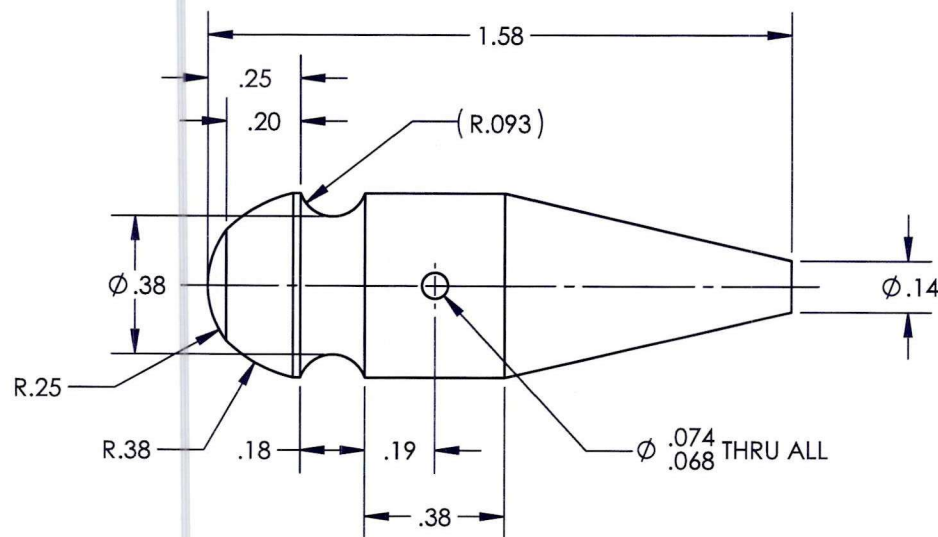
△ 1 EPOXY -5 SHAFT INTO -3 HAMMER HEAD & -7 HANDLE.

①
HAMMER, STEEL

DART AEROSPACE	
TITLE HAMMER, STEEL, BLADE CORROSION AND VOIDS DETECTION	
DWG NO. RBW109-3101-58-1-1	REV 3
MAT'L	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH	.XXX ± .010 FRACTIONS ± 1/8
SPEC	.XX ± .03 ANGLES ± 1°
	.X ± .1 SURFACES = 125/
DRAWN BY: DUERFELDT	1. BREAK ALL SHARP EDGES
CHECKED: DUERFELDT	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
QA APPR: LINDSAY	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
APPROVED: GILBERT	USED ON MODEL
SCALE 1:2	AW109/AW119
DATE 3/12/2015	SHEET 2 OF 5

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	16-0212	-3 CH'D FINISH WAS CAD PLATE YELLOW IS ZINC PLATE ASTM B633 TYPE I SC 2, CH'D MATERIAL WAS 1018/1020 IS 1018/1020 CR.	11/4/2016	RJC	JAG

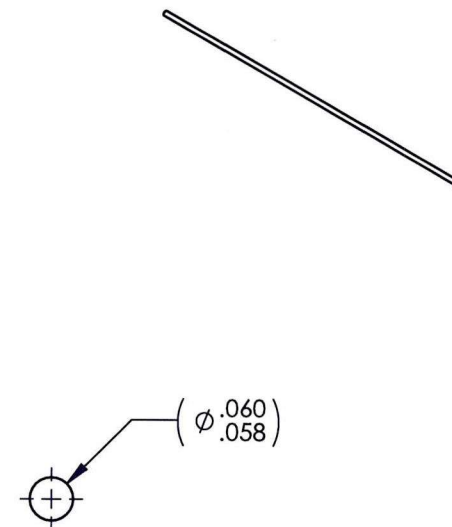
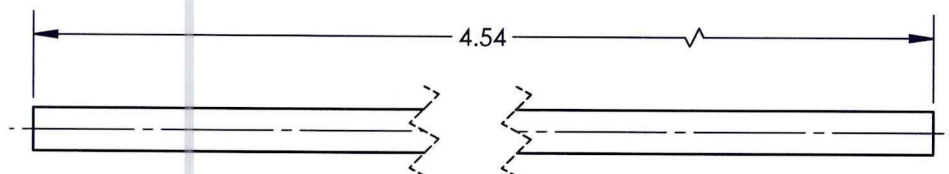


(-3)
HAMMER HEAD

DART AEROSPACE	
TITLE HAMMER, STEEL, BLADE CORROSION AND VOIDS DETECTION	
DWG NO. RBW109-3101-58-1-3	REV 3
MAT'L 1018/1020 CR	UNLESS OTHERWISE SPECIFIED
TREAT	DIMENSIONS ARE IN INCHES
FINISH ZINC PLATE	.XXX ± .005 FRACTIONS ± 1/8
SPEC ASTM B633 TYPE I SC 2	.XX ± .01 ANGLES ± 5°
DRAWN BY: DUERFELDT	.X ± .1 SURFACES = 125/
CHECKED: DUERFELDT	1. BREAK ALL SHARP EDGES
OPPS APPR: ANDERSON	.015 x 45° OR .015R
QA APPR: LINDSAY	2. DIMENSIONAL LIMITS APPLY
APPROVED: GILBERT	AFTER PLATING
SCALE 2:1	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
DATE 3/12/2015	USED ON MODEL
SHEET 3 OF 5	AW109/AW119

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	16-0212	-5 CH'D DIM WA S(Ø.059) IS (Ø.060/.058).	11/4/2016	RJC	JAG



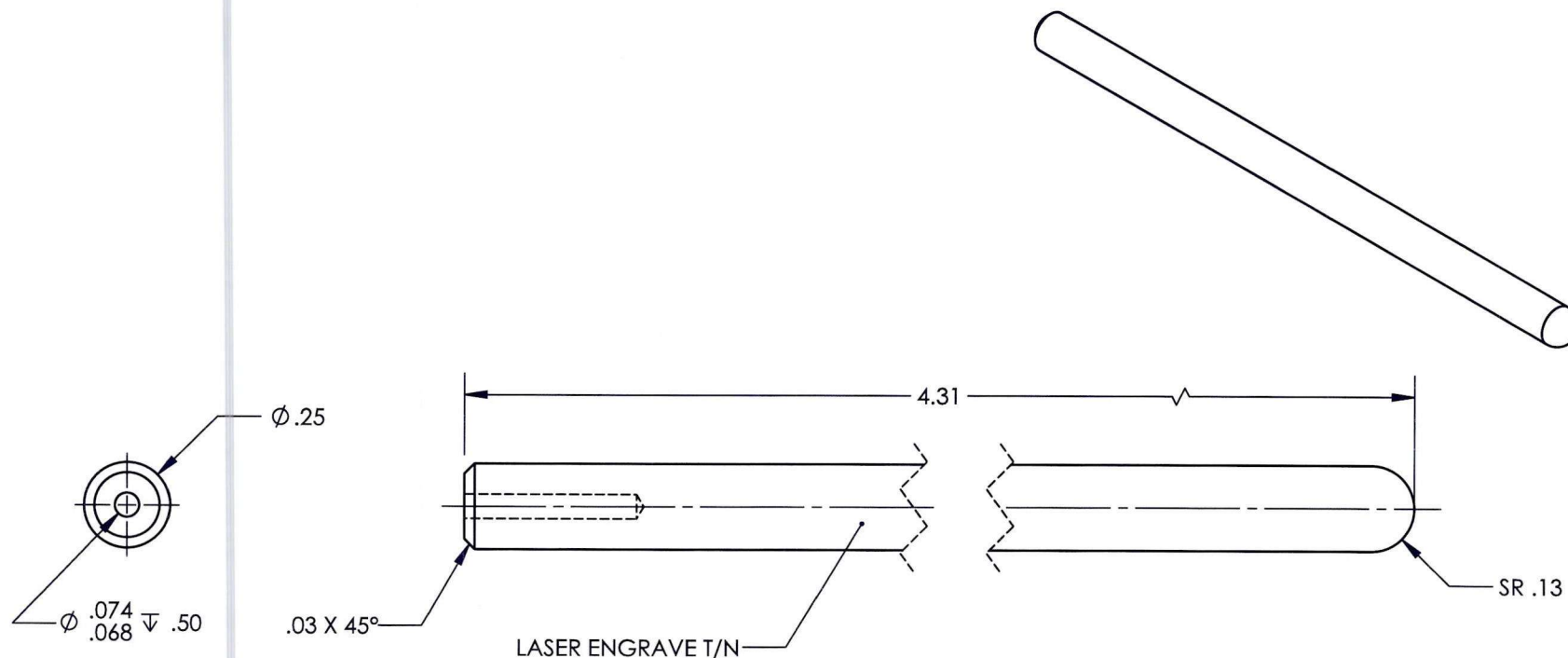
(-5)

SHAFT

DART AEROSPACE	
TITLE HAMMER, STEEL, BLADE CORROSION AND VOIDS DETECTION	
DWG NO. RBW109-3101-58-1-5	REV 3
MAT'L S.S.	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH	.XXX ± .005 FRACTIONS ± 1/8
SPEC	.XX ± .01 ANGLES ± 5°
	.X ± .1 SURFACES = 125 ✓
DRAWN BY: DUERFELDT	1. BREAK ALL SHARP EDGES
CHECKED: DUERFELDT	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
SCALE 4:1	USED ON MODEL
DATE 3/12/2015	AW109/AW119
SHEET 4 OF 5	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	16-0212	-7 CH'D DIM WAS Ø.24 IS Ø.25. CH'D ENGRAVE NOTE WAS LASER ENGRAVE T/N IS LASER ENGRAVE T/N, S/N, "MADE IN USA".	11/4/2016	RJC	JAG
3	17-0053	-7 CH'D ENGRAVE NOTE WAS LASER ENGRAVE T/N, S/N, "MADE IN USA" IS LASER ENGRAVE T/N.	2/20/2017	RJC	JAG



(-7)
HANDLE

DART AEROSPACE	
TITLE HAMMER, STEEL, BLADE CORROSION AND VOIDS DETECTION	
DWG NO. RBW109-3101-58-1-7	REV 3
MAT'L 6061	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH BLUE ANODIZE	.XXX $\pm$.005 FRACTIONS $\pm$ 1/8
SPEC MIL-A-8625F, TYPE II, CLASS II	.XX $\pm$.01 ANGLES $\pm$ 5°
	.X $\pm$.1 SURFACES = 125/
DRAWN BY: DUERFELDT	1. BREAK ALL SHARP EDGES
CHECKED: DUERFELDT	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
SCALE 2:1	USED ON MODEL
DATE 3/12/2015	AW109/AW119
SHEET 5 OF 5	



ENGINEERING ORDER # TEO17-644

SCALE: NTS

SHEET 1 OF 1

DRAWING NO. RBW109-3101-58-1

REV: ~~NC~~³ **EFF.:** NEXT ORDER

CHANGE CATEGORY

TITLE: HAMMER, STEEL, BLADE CORROSION AND VOIDS DETECTION

☐ MAJOR ☒ MINOR

DATE 17.09.07

APPROVED: *VM* 09/15/2017

QA APP.: PD 09/14/2017

MFG. APPR.: DP 09/11/2017

CHECKED: SAC 09/08/2017

DRAWN: VM 09/08/2017

TRANSACTION CODE (TC):
A-ADD C-CREATE
R-REVISE D-DELETE

REASON: NO EPOXY DETAILS

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USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION
FROM DART AEROSPACE LTD.

WAS : PART# RBW109-3101-58-1-1 Rev 3 CALLED : EPOXY (IN NOTES)
IS : PART# RBW109-3101-58-1-1 Rev 3 CALLED : EPOXY 3M DP460 AS PER QSI 015 (IN NOTES)

DOCUMENTS EFFECTED: ☐ PATTERN ☐ INSTALL INSTRUCTIONS ☒ BOM

EO17-644

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					